

Date: Monday, 22/10/2007 2:17:12 PM  
 User: Linda Lacelle

## Process Sheet

Split 1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 35295-2			Part Number	: D3560041	
Estimate Number	: 12578			Drawing Number	: D3560 UNDER REVIEW	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 22/10/2007 S.O. No. : N/A			Drawing Revision	: C	
Prsht Rev.	: NO			Material	: N/A	
First Issue	: N/A			Due Date	: 29/10/2007	
Previous Run	: 35029			Qty:	2 Um: Each	
Written By				Comment	: Est Rev:A New Issue 07.05.24 EC est rev B ECN 987 07.10.09 EC verified by: DD	
Checked & Approved By						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
Comment: Qty.: 1.4648 f(s)/Unit Total: 20.5065 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: M105950		
2.0	BAND SAW	BAND SAW :
Comment: BAND SAW Cut blanks 16.750" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: C 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Ch-ef Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: ARM
Job Number: 35295	Part Number: D3560041
Job Number:	
Seq. #:	Machine Or Operation:
5.0	QC8
	SECOND CHECK
Comment: SECOND CHECK	8.5 07/10/31 12
6.0	D35921
	PLATE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)	14.0000 Each(s)
PLATE	335331
7.0	LARGE FAB 1
	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1	14.0000 Each(s)
1-Weld assembly as per dwg D3560	
STEP:	
1- clean material (buff bracket and bottom of arm with blue pad )	11
2- set up bracket and arm on jig	11
3- preheat bracket and arm with torch	11
4- clean before welding with brush	11
5- set up machine to 135 amps	11
6- weld across bottom and top ends	11
7- reheat with torch ( 60° )	11
8- on one side weld from bottom to top half way	11
9- same for other side (half way)	11
10- from half way point weld the rest of the first side (ease off pedal near end)	11
11- same for remaining side (ease off pedal near end)	11
8.0	QC5
	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP	14.0000 Each(s)
9.0	QC9
	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION	14.0000 Each(s)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/12/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

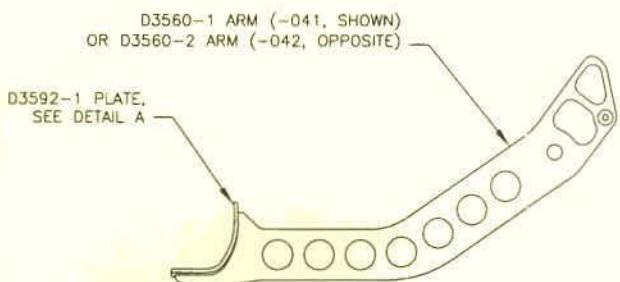
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 35295		Part Number: D3560041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
10.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  ② BL 07-12-03.
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
11.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  ② HD 07-12-03 (X2)
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
12.0	D2808 	Spacer 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) Spacer batch: B35330 X(2) mf 07-12-03		
13.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Press bushing in D3560 arm per dwg D3562 mf 07-12-03 ②		
14.0	QC5 	INSPECT WORK TO CURRENT STEP  ② S 07-12-03 (X2)
Comment: INSPECT WORK TO CURRENT STEP		
15.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <del>WAS</del> 07-12-03 X 2		
16.0	QC21 	FINAL INSPECTION/W/O RELEASE  ② D 07-12-10
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		U min 2007/12/10

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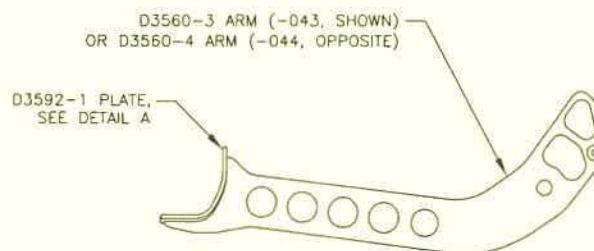
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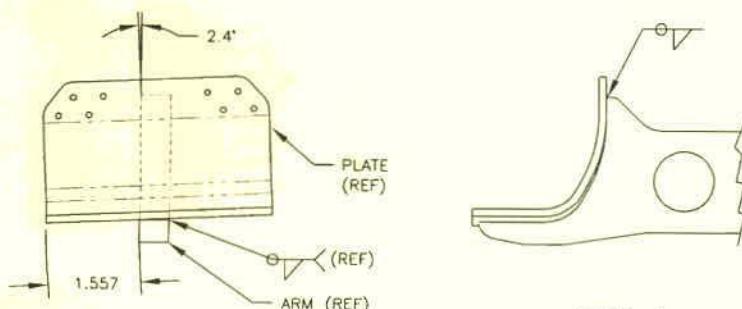
NOTE: Date & initial all entries



D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

#### GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
07.06.19  
UNDER REVIEW  
07.10.22 DC

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	99	DRAWN BY 99
CHECKED	99	APPROVED 99
DRAWING NO.	D3560	REV. C
DATE	07.06.19	SHEET 1 OF 3
TITLE	ARM WELDMENT	SCALE 1:4

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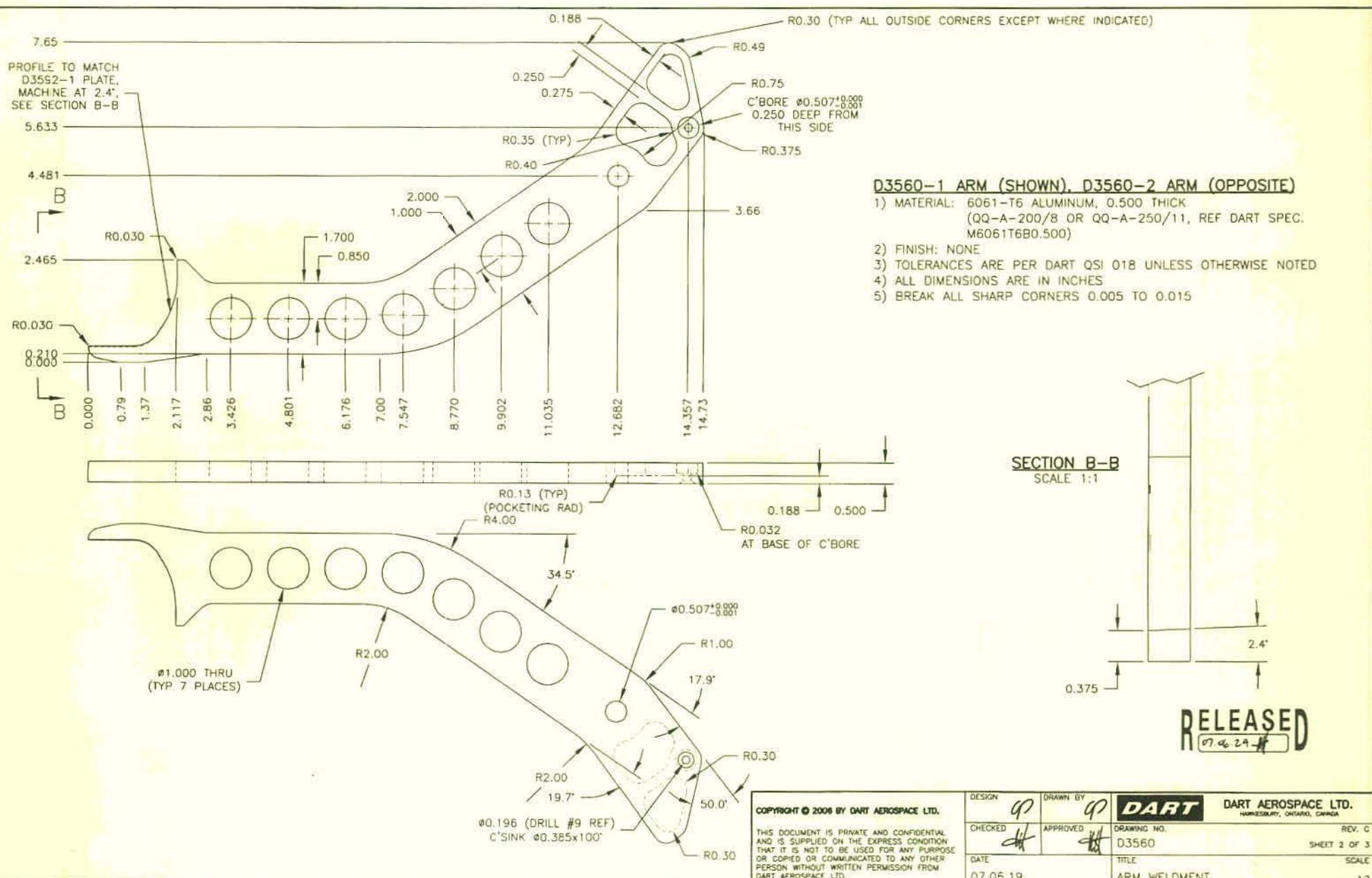
DART AEROSPACE LTD.  
HAMILTON, ONTARIO, CANADA

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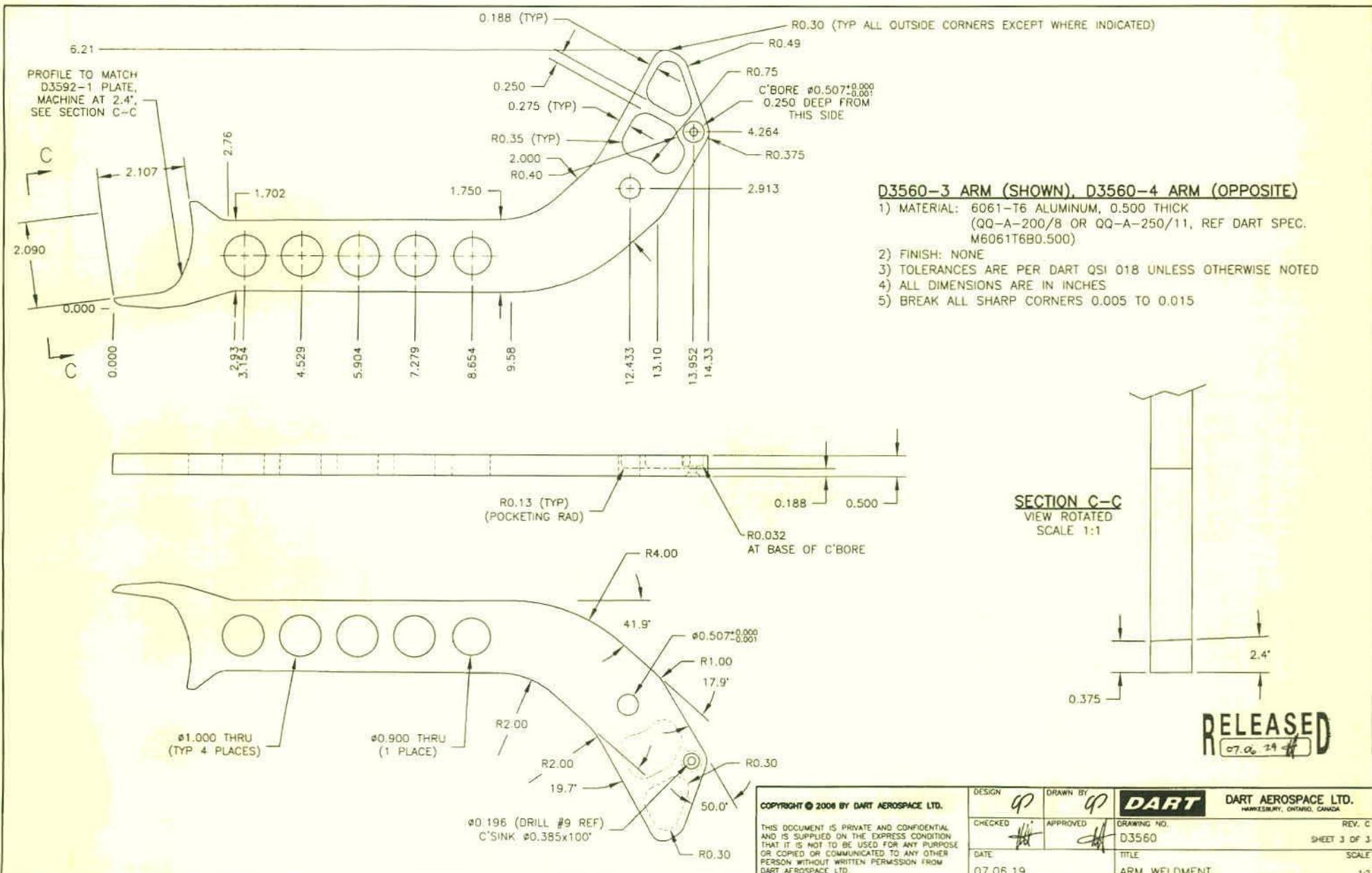


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DART AEROSPACE LTD	Work Order:	35245
Description: Arm	Part Number:	D3560-1
Inspection Dwg: D3560	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>34</u>
Date:	07.02.2019

Audited by:	J-L
Date:	07/10/29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	

W/O:

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